



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2600-3-BENT-RH
Job Sheet 200627



18 JTW

Part No: D2600-3-BENT-RH

Job Qty: 10 pcs

Part Name: Extrusion Bent RH

Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/13/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 10/14/19

Description: SIOP

Type: Stock

Note: DWG D2750 REV G SHEET 4, D2600 REV E SHEET 2 IPP REV:A 14.01.14 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Sign-off
100	Skidtubes - Bend - 1	10 pcs	10/14/19	10/14/19	0.23	4.98	Skidtubes - Bend	MGA
110	QC 5	10 pcs	10/14/19	10/14/19	0.00	0.00	QC 5 - 10	BE
							QC 5 - 12	
							QC 5 - 17	
							QC 5 - 18	
							QC 5 - 19	
							QC 5 - 22	
							QC 5 - 24	
							QC 5 - 3	
							QC 5 - 43	
							QC 5 - 49	
							QC 5 - 51	
							QC 5 - 58	
							QC 5 - 68	
							QC 5 - 9	
							QC 5 - 50	
							QC 5 - 30	
							QC 5 - 40	
							QC 5 - 61	
							QC 5 - 81	
120	Packaging 3-1 - Stock - B4B	10 pcs	10/14/19	10/14/19	0.00	0.00	Packaging 3 - 1 - B4B	
							Packaging 3 - 2 - B4B	
							Packaging 3 - 3 - B4B	
							Packaging 3 - 4 - B4B	
							Packaging 3 - 5 - B4B	
							Packaging 3 - 6 - B4B	
							Packaging 3 - 7 - B4B	
							Packaging 3 - 8 - B4B	
							Packaging 3 - 9 - B4B	
							Packaging 3 - 10 - B4B	
							Packaging 3 - 11 - B4B	



Container No: S216212



Part: D2600-3-BENT-RH

Job No: 200627

Serial No/Batch: S216212

Revision:

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 09/23/19

9/13/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

130 QC 21 - SA	10 pcs	10/14/19	0.00 0.00	Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	BE
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				QC 21 - SA - 21	DAS SEP 26 2019
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-53

Part Op 100 - (CNC Delta 100 Bender) Pick qty 1 D2600-3-130 extrusion 1-Deburr one end of extrusion 2-Bend using CNC
 Descriptions: bending machine as per program 2750.C and Folio 14 use bending aid DT9635 3- cut fwd end of tube as per dwg D2750
 4- cut aft end of tube as per dwg D2750
 110 - (QC5- Inspect part completeness to step on W/O)
 120 - (Identify as per dwg & Stock Location: LG002) LOCATION :LG002
 130 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-3-130	Extrusion Round 3" 350	10 pcs (1 ea)	100-Skidtubes - Bend - 1	S124531

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Skidtubes - Bend - 1	D2600-3-130	10	55	0

Part Specifications

Specifications could not be found.

Plex 9/13/19 10:55 AM Dart.lajeunesse.marie

SPECIFICATION CONTROL DRAWING

D2600-X-XXX EXTRUSION

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-200/8 OR AMS-QQ-A-200/8 OR ASTM B221
MINIMUM TENSILE YIELD STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 40 KSI
MINIMUM ELONGATION = 8%
A SAMPLE FROM EACH BATCH WILL BE FULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.006 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/M & B/N PER DART QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: D2600-1 = 0.078 lb/in, D2600-3 = 0.130 lb/in, D2600-5 = 0.045 lb/in, D2600-7 = 0.081 lb/in
- 8) NO TOOLING MARKS
- 9) FOR D2600-1, PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH (EX. D2600-1-160 IS 160" LONG).
D2600-1 EXTRUSION MANUFACTURED FROM:
- CARADON INDALEX DIE # MH-18870
- SIGNATURE ALUMINUM (BON-L) DIE # 897121
- 10) FOR D2600-3, PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH (EX. D2600-3-120 IS 120" LONG).
D2600-3 EXTRUSION MANUFACTURED FROM:
- CARADON INDALEX DIE # MH-18859
- SIGNATURE ALUMINUM (BON-L) DIE # 897122
- 11) FOR D2600-5, PART NUMBER IS D2600-5-XXX WHERE XXX IS CUT LENGTH (EX. D2600-5-108 IS 108" LONG).
D2600-5 EXTRUSION MANUFACTURED FROM:
- CARADON INDALEX DIE # MS-18871
- 12) FOR D2600-7, PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH (EX. D2600-7-125 IS 125" LONG).
D2600-7 EXTRUSION MANUFACTURED FROM:
- CARADON INDALEX DIE # MS-18872

RELEASED
2012-07-11

200627 MJS
19-09-13

REV.	DESCRIPTION	BY	DATE
E	REFORMAT DWG. ALL DIMS & TOL. UPDATE TO MATCH INFO DIE DWGS. ADD ASTM B221 SPEC (D8-1)	CP	11.10.18
D	INCREASE MIN. UTS TO 40 KSI	DS	98.08.20
C	ADD D2600-3. UPDATE D2600-1 WIDTH. ADD DIE NO.	DS	98.04.16
B	CHANGE MATERIAL SPEC.	DS	97.09.09
A	NEW ISSUE	DS	97.01.21
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.10.18		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

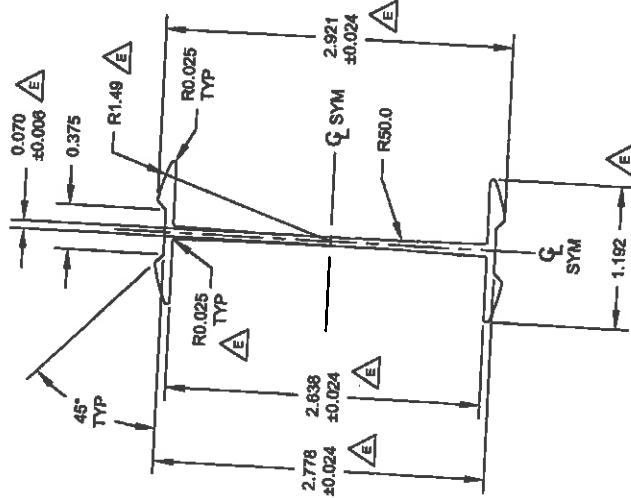
DRAWING NO.
D2600

REV. E
SHEET 1 OF 3

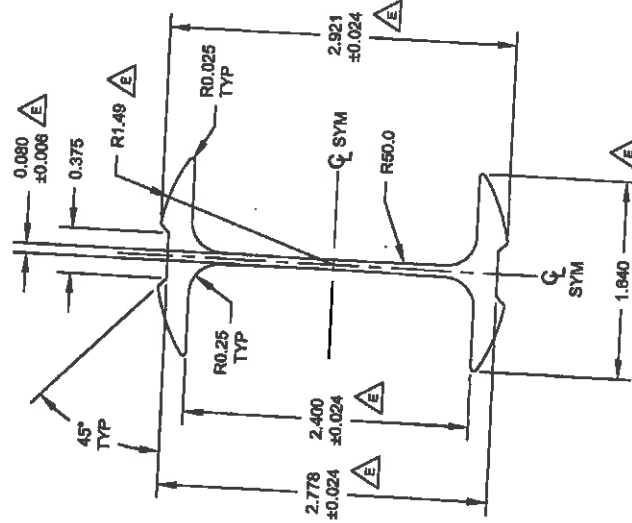
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EXTRUSION

SCALE
N/A

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D2600-5 EXTRUSION

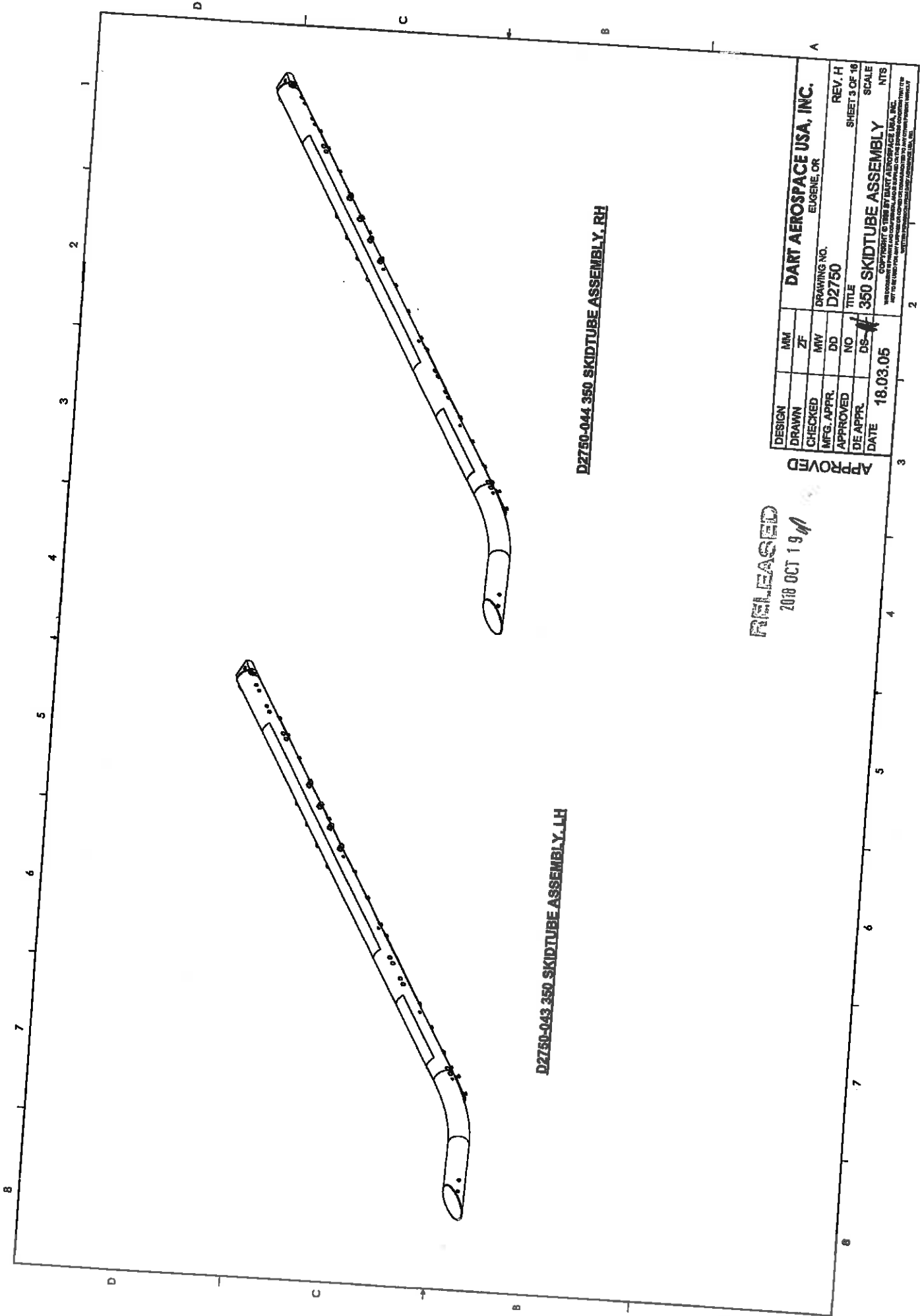


D2600-7 EXTRUSION

RELEASED
68 2012-01-16

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CHECKED	ASS	DRAWING NO.
MFG. APPR.	ASS	D2800
APPROVED	ASS	REV. E
DE APPR.	ASS	SHEET 3 OF 3
DATE	11.10.18	TITLE
		EXTRUSION
		SCALE
		NTS

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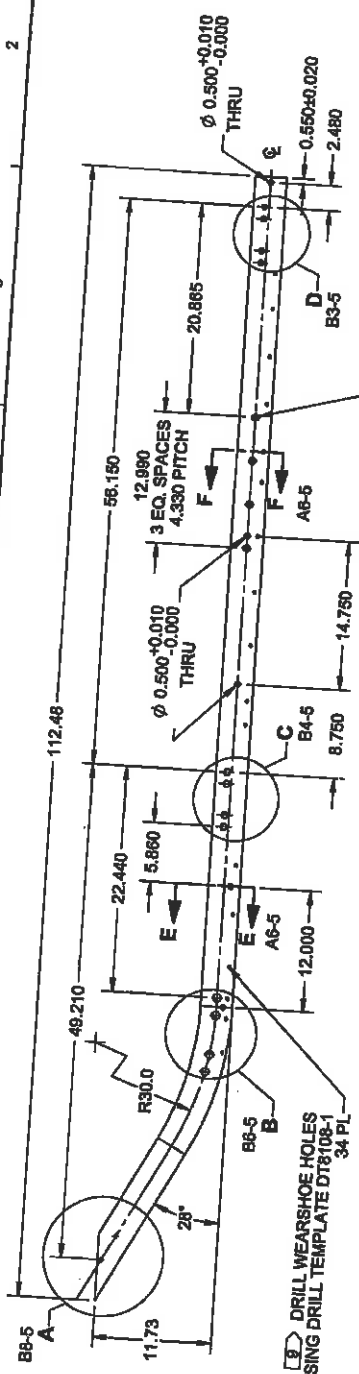
D2750-043 350 SKIDTUBE ASSEMBLY, LH

D2750-044 350 SKIDTUBE ASSEMBLY, RH

RELEASED
2018 OCT 19

DESIGN		MM	DART AEROSPACE USA, INC.	
DRAWN		ZF	ELUGENE, OR	
CHECKED	MMV	DRAWING NO.	REV. H	
MFG. APPR.	DD	D2750	SHEET 3 OF 16	
APPROVED	NO	TITLE	350 SKIDTUBE ASSEMBLY	
DATE	18.03.05	SCALE	NTS	

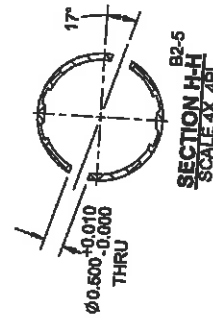
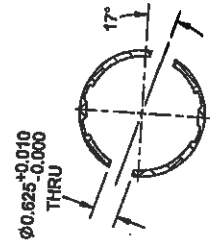
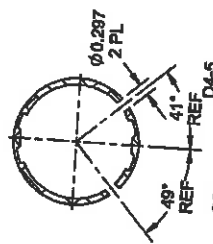
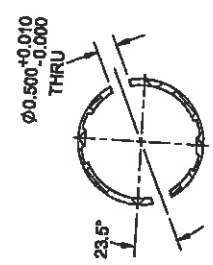
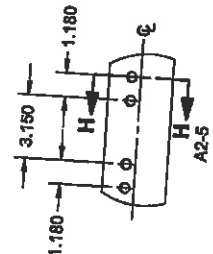
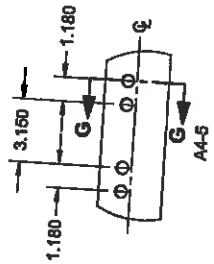
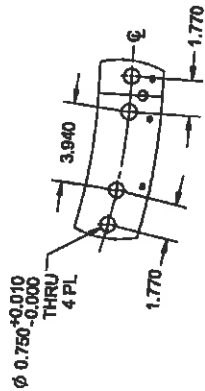
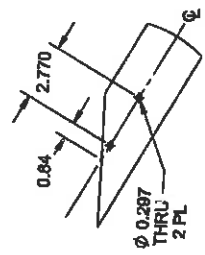
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D2750-1 LH SKIDTUBE

DRILL WEARSHOE HOLES
USING DRILL TEMPLATE DT8108-1

OUTBD
MAX ALLOWABLE
TWIST ON FWD BEND
(VIEW LOOKING FWD)



RELEASED
2018 OCT 19

SECTION E-E
SCALE 4X, 2 PL

SECTION F-F
SCALE 4X, 17 PL

SECTION G-G
SCALE 4X, 4 PL

SECTION H-H
SCALE 4X, 4 PL

DART AEROSPACE USA, INC. EUGENE, OR			
DESIGN	MM	ZF	REV. H
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DATE	18.03.05		
TITLE		SHEET 8 OF 16	
350 SKIDTUBE ASSEMBLY		SCALE	
NTS		REV. H	
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DETAILS
SCALE 2X
D8-13 RELEASED
2010 OCT 19 09

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐					
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QS1042)					
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____		Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐	